

Work Order ID 120460

120460

Page 1

Wednesday, June 04, 2014 3:05:50 PM

Item ID: D3295-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacment Interior Window For -111
 Start Date: 6/23/14 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 6/23/14 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-06-09 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3295 | E |

100 FLOW WATER JET 0.00 DAS 23 9-89 14-09-9

100

Waterjet

FLOW CNC Waterjet

, 125" Lexan.

Memo

ENSURE PLASTIC BLOCK ARE ON TABLE BEFORE CUTTING PARTS

1-Cut D3295-1 as per Dwg D3295

Dwg Rev: E

Prog Rev: E

2-Remove plastic and wrap in saran wrap.

3-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Quality Control

Memo

0.00

DAS 23 9-89 14-09-9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
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| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
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| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

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|--|--|---|---|

Work Order ID 120460

120460

Page 3

Wednesday, June 04, 2014 3:05:50 PM

Item ID: D3295-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacment Interior Window For -111
 Start Date: 6/23/14 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 6/23/14 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150 | Identify as per dwg & Stock Location: <u>ST41</u> | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 160 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

4x SP 14-9-11
 14/9/12 JH
 MF
 14-9-11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
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| Training | | | | | | | | | |
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FAULT CATEGORY

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|--|--|---|---|

Picklist Print

Wednesday, June 04, 2014 3:05:49 PM

Page 1

Work Order ID: 120460

120460

Parent Item: D3295-041

D3295-041

Parent Item Name: Replacment Interior Window For -111

Start Date: 6/23/14

Required Date: 6/23/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C05.06.20D3295-1 no longer made in-houseKJ/JLM
IPP Rev:D Added DT8822 07-03-20 JLM
IPP Rev:E Returned Manufacturing In House 07-06-26 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|-------------------|
| MLEXS.125-9034-01 | | Purchased | No | | | 100 | sf | 226.0000 | 1.24 | 6 | | | DAS 23 9-89 |
| *MI FXS 125-9034-01* | | | | | | | | | | 6 | | | 14-09-9 |

1/8" 9034 Lexan Sheet

Location

Loc Qty

Loc Code

MAT019

226

125052

73

m128667

153

125052.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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|--|--|---|--|

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|--|--|---------------------|--------|
| DART AEROSPACE LTD | | Work Order: | 126466 |
| Description: Window | | Part Number: | D3295 |
| Inspection Dwg: D3295 Rev: E | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.156 | +0.005/-0.001 | 0.157" | - | | V | Jkmo1 |
| 17.13 | +/-0.030 | 17.13" | - | | T | Jkmo7 |
| 10.43 | +/-0.030 | 10.43" | - | | V | Jkmo8 |
| 14.35 | +/-0.030 | 14.35" | - | | T | |
| 8.98 | +/-0.030 | 8.98" | - | | V | |
| 0.625 | +/-0.010 | 0.628" | - | | V | |
| 7.109 | +/-0.010 | 7.109" | - | | V | |
| 15.845 | +/-0.010 | 15.845" | - | | T | |
| 2.308 | +/-0.010 | 2.308" | - | | V | |
| 5.420 | +/-0.010 | 5.420" | - | | V | |
| 9.402 | +/-0.010 | 9.402" | - | | V | |
| 1.312 | +/-0.010 | 1.312" | - | | V | |
| 6.260 | +/-0.010 | 6.260" | - | | V | |
| 12.520 | +/-0.010 | 12.520" | - | | T | |
| 0.313 | +/-0.010 | 0.313" | - | | V | |
| 3.750 | +/-0.010 | 3.750" | - | | V | |
| 8.150 | +/-0.010 | 8.150" | - | | V | |
| 9.006 | +/-0.010 | 9.006" | - | | V | |
| 0.125 | +/-0.010 | 0.125" | - | | V | |
| | | | | | | |
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DAS

DAS
38
9-89

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|---------------------|------------|--------------------|---------|------------------------------|--|
| Measured by: | 23 9-89 | Audited by: | | Preliminary Approval: | |
| Date: | 14-09-9. | Date: | 14-9-10 | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-------------------------|------------|----------|
| A | 07.11.23 | New Issue P/O D3295-041 | KJ/EC/DD | |
| B | 13.02.27 | Dwg Rev updated | KJ | |

| ITEM | QTY -041 | QTY -041B | P/N | DESCRIPTION |
|------|-------------|--------------|------------|---------------------|
| | X | | D3295-041 | FLOOR WINDOW |
| | | X | D3295-041B | FLOOR WINDOW, BLANK |
| 1 | 1 | | D3295-1 | WINDOW |
| 2 | | 1 | D3295-1B | WINDOW, BLANK |
| 3 | 1 | 1 | D2728-1 | DECAL |

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 120460 MJS

14-06-09

RELEASED
2012-11-21

D3295-041 FLOOR WINDOW

△ D3295-041B FLOOR WINDOW, BLANK

NOTES:

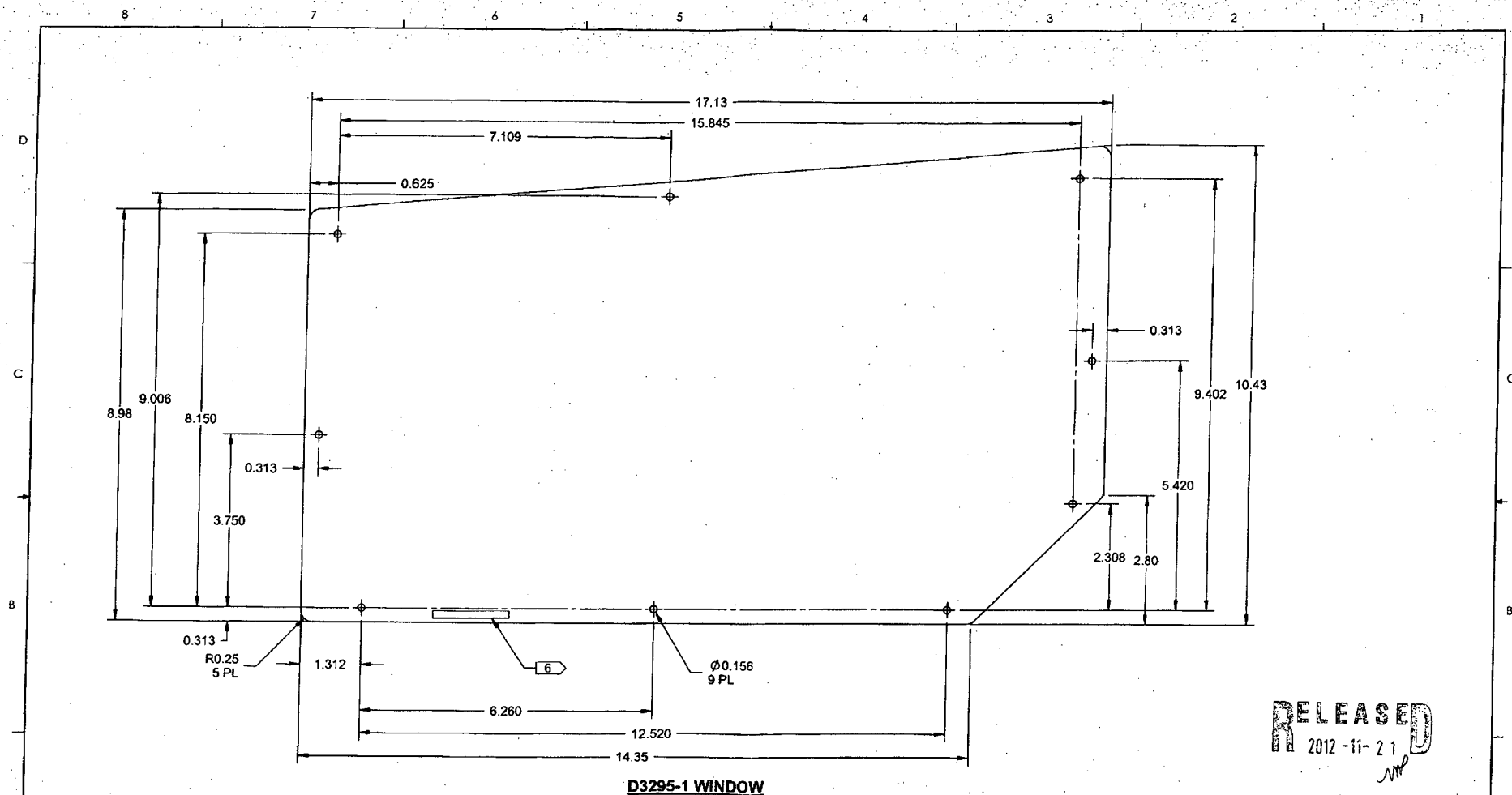
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) N/A
- 6) ENSURE SURFACE IS FREE OF DIRT/GREASE PRIOR TO APPLICATION OF SELF-ADHESIVE DECAL
- 7) WEIGHT: D3295-041/-041B = 0.87 lbs

| | | | |
|------------|--|-----|----------|
| E | ADD D3295-041B/-1B. REF. PAR12-223. | MB | 12.11.15 |
| D | REVISE MATERIAL TO LEXAN 9034 FROM POLYCAST ACRYLIC SHEET. ZONE A8 SH 2 ADD MISSING DIMENSION PER NCR 247. ZONE C3 SH 2 REFORMAT DRAWING | MP | 07.11.07 |
| C | CHANGE TEMPLATE # TO DT8822 | SSH | 07.02.21 |
| B | UPDATE MATERIAL PER NCR 029 | CP | 06.04.13 |
| A | NEW ISSUE | CP | 04.06.28 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 12.11.15 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3295
REV. E
SHEET 1 OF 3
TITLE
FLOOR WINDOW
SCALE
NTS

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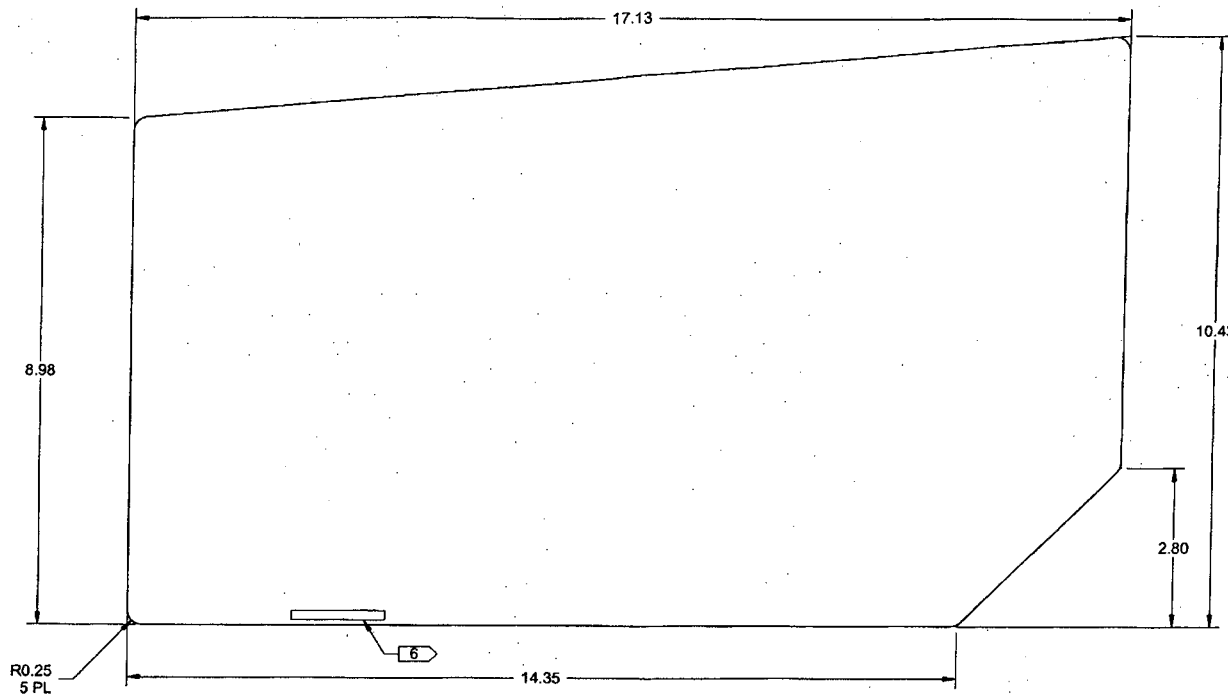


RELEASED
2012-11-21

NOTES:

- 1) MATERIAL: LEXAN 9034, 0.125 THICK
REF DART SPEC. MLEXS.125-9034-01
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3295-041" AND B/N "BXXXXX" PER DART QSI 044 6.4 (VIBRATING STYLUS)
USING LETTERS 0.125 TO MAX DEPTH OF 0.005. LOCATE APPROXIMATELY AS SHOWN
- 7) WEIGHT: 0.87 lbs

| | | | |
|---|----------|--|--------------|
| DESIGN | DP | DART AEROSPACE LTD | |
| DRAWN | DP | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | DP | DRAWING NO. | REV. |
| MFG. APPR. | DP | D3295 | SHEET 2 OF 3 |
| APPROVED | DP | TITLE | SCALE |
| DE APPR. | DP | FLOOR WINDOW | NTS |
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D3295-1B WINDOW

RELEASED
2012-11-21
JMP

NOTES:

- 1) MATERIAL: LEXAN 9034, 0.125 THICK
REF DART SPEC. MLEXS.125-9034-01
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3295-041B" AND B/N "BXXXXX" PER DART QSI 044 6.4 (VIBRATING STYLUS)
USING LETTERS 0.125 TO MAX DEPTH OF 0.005. LOCATE APPROXIMATELY AS SHOWN
- 7) WEIGHT: 0.87 lbs

| | | | |
|--|----------|--|--------------|
| DESIGN | GP | DART AEROSPACE LTD | |
| DRAWN | GP | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | GP | DRAWING NO. | REV. E |
| MFG. APPR. | GP | D3295 | SHEET 3 OF 3 |
| APPROVED | GP | TITLE | SCALE |
| DE APPR. | GP | FLOOR WINDOW | NTS |
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